



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN RAPID 68 S**

PATTERN: DIN E 6-UM 60 ST

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Mo	Cr	V

APPLICATION FIELD	Indicated for covering in carbon steel, manganese steel, cutting tools steel and fused iron. Among the main applications there are: Punctures, impressions' matrix, forging, cutting and pressing, cutting knives and scissors. The maximum job temperature must not exceed 550°C.					
TECHNICAL CHARACTERISTICS	Special electrode of tools steel, with excellent cutting quality, developed for applications which require high tenacity, connected to high resistance to shock and lesions, as well as, with moderated abrasion resistance. The hardness of the deposit can be altered by thermic treatment.					
MECHANICAL PROPERTIES	Hardness: 57 a 60 HRc					
OPERATIONAL CHARACTERISTICS	For: C.A or C.C-					
	Welding Position: ---					
	Ø In mm	2,50x350mm	3,25x350mm	4,00x350mm		
	Amperage Package	60-90 A 5 kg	80-100 A 5 kg	120-160 5 kg		
WELDING TECHNIQUES	The parts to be welded must be free of oil, grease, ink, oxides or any other kind of superficial contamination. When the welding is done on steel tools and connected steel, must be calculated the equivalent carbon, to determine the temperature of pre-heating, which should be constantly kept during the welding process, later, should be done a slow cooling process, in lime-klin or oven. The welding must be done quickly oscillating the electrode, keeping a short arch.					